












Date: Wednesday, 3/8/2006 10:39:00 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: EYEBALL ADAPTER
Job Number	: 26134		
Estimate Number	: 12239		
P.O. Number	: N/A	Part Number	: D34801
This Issue	: 3/8/2006 S.O. No. : N/A	Drawing Number	: D3480 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 3/31/2006
Checked & Approved By	: <u>06.03.08</u>	Qty:	40 Um: Each
Comment	: est rev. A 06.02.07 new issue EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	OUTSIDE SERVICE	OUTSIDE SERVICES	
			
Comment: Sub-Contracting Issue P/O: <u>00000768</u> <u>06/03/09</u> Email or Ship DXF file to vendor Laser Cut per Dwg D3480 flat pattern D3480-1F Material release note required			
2.0	D34801F	Flange flat pattern	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s) DOUBLER FLAT PATTERN			
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached			
4.0	QC6	DIMENSIONAL CHECK	
			
Comment: DIMENSIONAL CHECK			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per dwg D3467 using DT8857			
<p style="text-align: center; font-size: 2em; transform: rotate(-10deg);"> Permanent Changes <u>06.03.28</u> </p>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:39:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 26134

Part Number: D34801

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Stock as 3480-1F

06.03.28

(34)

PTD

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

(37)

06.03.29

U 06.03.29

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		One kept as template	18	06/03/20	1	18 CEN	18 QC	
	7	Stock as D3480-1F Permanent Change				18 CEN	18 QC	

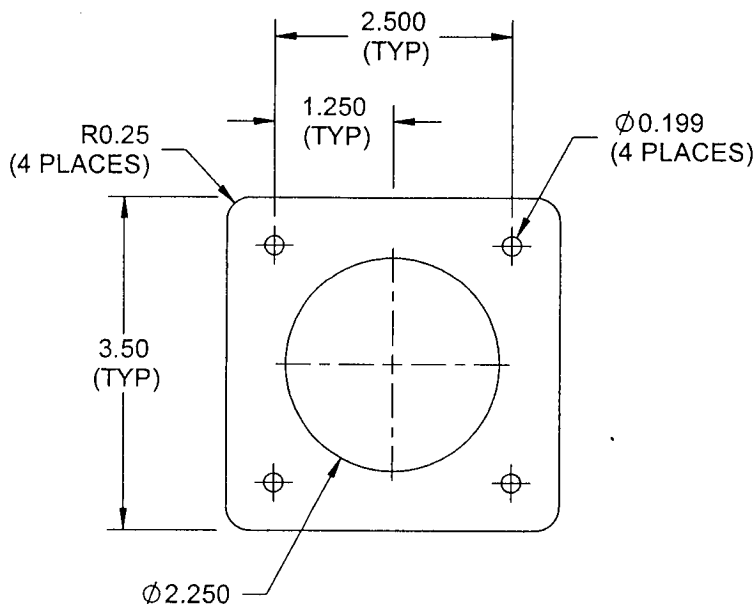
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/20
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

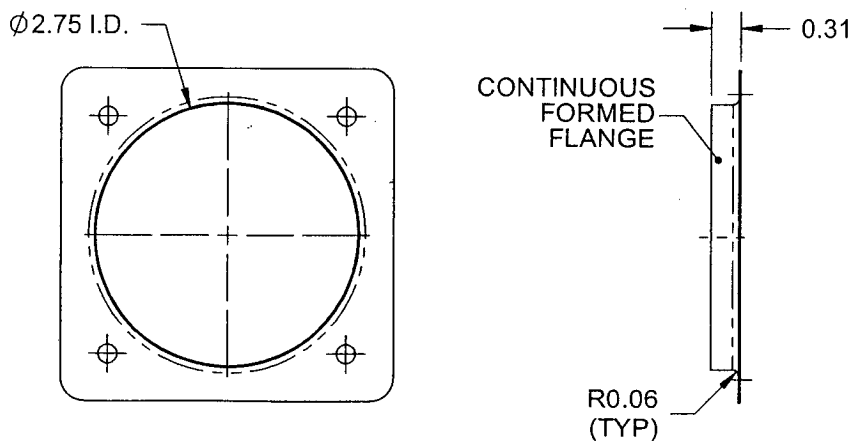
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3480	REV. A SHEET 3 OF 6
DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



D3480-1F FLAT PATTERN



D3480-1 FLANGE
(MAKE FROM D3480-1F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



3/17/06

604-946-453 ATTN: PETE

03/17/2006 14:36 FAX 604 946 4153
03/17/2006 14:18 FAX 604 272 9137INDUSTRIAL LASER CUTTING
INTEGRIS METALS002
001/004

3/17/2006 1:57 PAGE 001/002 Fax Server


Ryerson

T-726 P.007/015 F-597

253-288-8888

FROM-INTEGRIS

MAY-17-2006 16:05

		AK Steel Corporation Metallurgical Test Report Coshocton Works Coshocton, OH 43812		Page 1 Lead No. 7410672 SER No. 7410672											
		INTEGRIS METALS PO BOX 340 MINNEAPOLIS, MN 55440		INTEGRIS METALS 306 "B" STREET ALBURN, WA 98001											
MILL ORDER NO. 772185-0191 PROCESSOR ORDER NO. 427135-01 BUYER'S ORDER NO. 427135-01		PART NO. 74151497 EXHAUST UNITS -PRODUCT- METRIC UNITS 318X1001 48.0000 X COIL													
SKID ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT											
SK07131A3	1	7250151	050919-01	3,465 LBS. 4012 KG.											
SK07131A4	1	7250151	050919-01	3,470 LBS. 4013 KG.											
SK07131A5	1	7250151	050919-01	3,525 LBS. 4086 KG.											
SK07131A6	1	7250151	050919-01	3,441 LBS. 3991 KG.											
TOTAL SKIDS	TOTAL PIECES			TOTAL NET WEIGHT											
4	4			13,841 LBS. 15075 KG.											
L-Lab Analysis of Heat P-Product Analysis of Parent Coil CHEMICAL ANALYSIS															
ID	C	MN	P	S	SI	CR	NI	MO	N	CU	CO				
L 7250151	.049	1.39	.027	.001	.35	18.18	8.05	.35	.04	.30	.12				
SHIPPING DATE: 03/13/2005 REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.						PRODUCT DESCRIPTION CR SBT TYPE 304 STAINLESS #2B FINISH SLIT EDGE * AMS 3512 & ALL TECH REQS HAVE BEEN MET UNLESS MARKED TO OR NOTED OTHERWISE * A STR A 240 -04 EX PARA 3.1.1.9 ELONG WILL BE DETERMINED BY ASTM E 8 * ASTM A 490 -01 EX PARA 19.1.1 ELONG WILL BE DETERMINED BY ASTM E 8 H & S EX PARA 20.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASTM A 866 -03 * IN-011 Rev 0, * IN-011 0 * BUYER PART# 74251497 * ASME SA-240 SECTION II PART A (2001 ED. 2002 ADDENDA) EX PARA 3.1.1.9 ELONG WILL BE DETERMINED BY ASTM E 8 * EN-10204 3.1.5									
PARENT COIL ID	FOR (R/T)	DIR (L, T, D)	COND	% ELONG 2 INCH MEASURED	TENSILE STRENGTH (KSI)	YS. % OFFSET (KSI)	ROCKWELL HARDNESS Total	ROCKWELL HARDNESS Front							
050919-01	T	T	AS SUPPLIED	71.0	125.2	27.1	72	74							
*** CONTINUED ON NEXT PAGE ***															

Fax Server

T-726 P.008/015 F-527

002/004

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K8
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 40TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 416824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MRAS
CORROSION: ASTM A262/02aE; 180Bend-OK
Buyer Part: 4288441
304 2B .1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O	UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV			
Tensile Strength (UTS)	93.3	KSI	F	TRANSV			
Rockwell B	85		F	TRANSV			
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV			
Rockwell A	85		T	TRANSV			

Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

Comments

1002
0004
003/004

INDUSTRIAL LASER CUTTING
INTEGRIS METALS

03/17/2006 14:37 FAX 604 946 4153
04/20/2006 08:27 FAX

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 2
Heat/Lot : 86K8
TIN : B42748

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 Q08763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GURLEPH, OMN K123
Control #: S0C60214
Part #: 74270441
.135 X .48 X .96

Date: 03/17/06

SOLD TO: INDIAN LAKE

TO 110880

S/O 90-374786 - 02

[Signature] 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.